



Dart Aerospace Ltd.
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Canada

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D3204-3

Job Sheet 193078



Part No: D3204-3

Job Qty: 5 pcs

Part Name: Arm



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/8/19

Job Tracking No:

Due Date: 4/16/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	4/16/19	4/16/19	0.00	0.01	Bandsaw - 1		Small 19/04/17
110	HAAS 4 Axis - B4B	5 pcs	4/16/19	4/16/19	0.33	1.50	HAAS - 1 - B4B		Small 19/04/17
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	5 pcs	4/16/19	4/16/19	0.00	0.00	QC 8 - 12		Small 19/04/17
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Packaging 3-1 - Stock - B4B	5 pcs	4/16/19	4/16/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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Container No: S173310



Part: D3204-3

Job No: 193078

Serial No/Batch: S173310

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/17/19

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					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	12
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	5 pcs	4/16/19	0.00 0.00	QC 21 - SA - 21		DAS
				QC 21 - SA - 70	APR 18 2019	70
				QC 21 - SA - 53		9-89

Part Op **100** - (Bandsaw) Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000)
 Descriptions: **110** - (HAAS CNC Vertical Machine) 1- Machine as per Folio FA344 and Dwg D3204 Identify as D3204-3
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____) LOCATION : WA001-3
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X02.500	6061-T6 Bar .500 X 2.50	2.7400 ft (.548 ea)	100-Bandsaw - 1	5156594

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.500X02.500	3	12	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	6.000Inches $\pm$ 0.030	6.030 5.970	6.000	
2	Arm	5.250Inches $\pm$ 0.030	5.280 5.220	5.250	
3	Arm	0.776Inches $\pm$ 0.010	0.786 0.766	.772	
4	Arm	0.760Inches + 0.005 - 0.000	0.765 0.760	Diameter .761	
5	Arm	0.080Inches $\pm$ 0.010	0.090 0.070	.079	
6	Arm	0.500Inches $\pm$ 0.010	0.510 0.490	Radius .500	
7	Arm	2.373Inches $\pm$ 0.010	2.383 2.363	2.370	
8	Arm	0.750Inches $\pm$ 0.010	0.760 0.740	.751	
9	Arm	0.380Inches $\pm$ 0.010	0.390 0.370	Radius .380	
10	Arm	0.375Inches + 0.001 - 0.000	0.376 0.375	Diameter .375	
11	Arm	0.300Inches $\pm$ 0.010	0.310 0.290	.297	

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